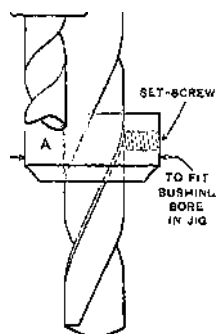


changing the drilling and the reaming bushings (even though they are carefully marked) and thus spoiling the tools or the work. An improvement over the individual slip bushings is



*n*

LLJJ



.-DIAMETER BUSHING BORE  
IN JIG

Fig. 21. Drill  
with Guide  
Bushing  
attached

Fig. 22. Stationary  
Guide for Multiple  
Drilling and  
Reaming Tools

the plate bushing holder, which is especially useful on such work as crankcases, cylinders, etc., and in practically all work where six or more holes are to be drilled. The work is placed in a box jig or frame in which there are either two dowel-pins